



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D4037-3
Job Sheet 168691



Part No: D4037-3

Job Qty: 2 ea

Part Name: Fwd Crossbeam



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 11/21/17

Job Tracking No:

Created By: Mario Poulin

Due Date: 12/14/17

Type: SOLD

Description:

Note: DWG REV E IPP REV:A NEW ISSUE 09-12-14 JLM VERIFIED BY:EC IPP REV:B AS PER REV B 10-04-19
JLM VERIFIED BY:EC IPP REV:D AS PER ECN 11-554 11-05-24 JLM VERIFIED BY:DD IPP REV C:AS PER
ECN 10-563 10-09-28 JLM VERIFIED BY:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	2 Ea	12/13/17	12/13/17	0.00	0.00	Start Up Waterjet		SC
100	Waterjet	2 pcs	12/13/17	12/13/17	0.00	2.11	Waterjet1		SC
110	CNC Vertical Machining	2 pcs	12/13/17	12/13/17	2.85	5.71	HAAS 1		Kt 17-12-21
120	QC	2 pcs	12/13/17	12/13/17	0.00	0.00	QC2		Kt 17-12-21
130	QC	2 pcs	12/13/17	12/13/17	0.00	0.00	QC8		K.A 17-12-22
140	HandFinish	2 pcs	12/13/17	12/13/17	0.00	0.42	HandFinish1		2017-12-21 JSL
150	Powdercoat	2 pcs	12/14/17	12/14/17	0.00	0.43	Powdercoat1		BL 17-12-21
160	QC	2 pcs	12/14/17	12/14/17	0.00	0.00	QC3		DEC 22 2017
170	Packaging	2 pcs	12/14/17	12/14/17	0.00	0.00	Packaging3		DEC 22 2017
180	QC21-SA	2 Ea	12/14/17	12/14/17	0.00	0.00	QC21		DEC 22 2017

Part Op 100 - Cut blank as per file D4037-3_BLANK

Descriptions: 110 - MACHINE AS PER FOLI FA878 AND DWG

M 138467. START: 4:20 OUT: 300° FINISH: 4:50.

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	M6061T6B1.000X16.000	8	26	0	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____ Date : _____	DISPOSITION Rework ☐ Scrap ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border-collapse: collapse;"> <tr> <td style="width:33%;">ab</td> <td style="width:33%;">Water Jet</td> <td style="width:33%;">Engineering</td> </tr> <tr> <td>ng</td> <td>Prod. Eng. Coord.</td> <td>Quality</td> </tr> <tr> <td>te</td> <td>Rec/Store/Packaging Supplier</td> <td>Other</td> </tr> </table> Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K6A 1K7 CANADA TEL.: 1 613 632-5200 Email: sales@dartaero.com www.dartaerospace.com	ab	Water Jet	Engineering	ng	Prod. Eng. Coord.	Quality	te	Rec/Store/Packaging Supplier	Other
ab	Water Jet	Engineering									
ng	Prod. Eng. Coord.	Quality									
te	Rec/Store/Packaging Supplier	Other									
 S013126 Fwd Crossbeam PART NO: Revision: Operation: Change No: D4037 - 3 Start up Operation Mfg Date: 11/23/17 Job No: 168691		<table style="width:100%; border-collapse: collapse;"> <tr> <td style="width:50%; height: 100px; vertical-align: bottom;"> ion </td> <td style="width:50%; vertical-align: top;"> MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval </td> </tr> </table>	ion	MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval							
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DART AEROSPACE LTD	Work Order:	168691
Description: Fwd Crossbeam	Part Number:	D4037-3
Inspection Dwg: D4037 Rev: E		Page 1 of 2

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
41.66	+/-0.030	41.66	✓		tape	
0.92	+/-0.030	0.918	✓		Kt-05	verm
1.75	+/-0.030	1.750	✓		" "	" "
0.92	+/-0.030	0.918	✓		" "	" "
2.125	+/-0.010	2.125	✓		" "	" "
Ø0.316	+0.006/-0.001	0.316	✓		" "	" "
Ø0.391	+0.006/-0.001	0.391	✓		" "	" "
0.28	+/-0.030	0.281	✓		" "	" "
R0.19	+/-0.030	0.190	✓		R-6	
0.63	+/-0.030	0.625	✓		Kt-05	verm
1.50	+/-0.030	1.502	✓		" "	" "
1.20	+/-0.030	1.200	✓		" "	" "
1.95	+/-0.030	1.955	✓		" "	" "
6.00	+/-0.030	6.00	✓		tape	
10.54	+/-0.030	10.54	✓		" "	" "
1.38	+/-0.030	1.375	✓		Kt-05	verm
1.75	+/-0.030	1.750	✓		" "	" "
7.79	+/-0.030	7.79	✓		31006	H-G
5.80	+/-0.030	5.80	✓		" "	" "
2.250	+/-0.010	2.250	✓		Kt-05	verm
0.875	+/-0.010	0.875	✓		" "	" "
6.000	+/-0.010	6.025	✓		" "	" "
7.75	+/-0.030	7.750	✓		" "	" "
1.125	+/-0.010	1.125	✓		" "	" "
9.29	+/-0.030	9.290	✓		tape	
5.17	+/-0.030	5.170	✓		" "	" "
10.79	+/-0.030	10.790	✓		31006	H-G
0.91	+/-0.030	0.910	✓		Kt-05	verm
0.09 x 45°	+/-0.030 x +/-0.5°	0.090 x 45	✓		" "	" "
0.31	+/-0.030	0.325	✓		" "	" "
0.25	+/-0.030	0.250	✓		" "	" "
0.530	+/-0.010	0.527	✓		teles	
0.25	+/-0.030	0.234	✓		mxm-02	micro
0.550	+/-0.010	0.550	✓		Kt-05	verm
3.00	+/-0.030	3.003	✓		Kt-05	verm
2.00	+/-0.030	2.000	✓		" "	" "
1.00	+/-0.030	1.019	✓		" "	" "

DART AEROSPACE LTD		Work Order:	
Description: Fwd Crossbeam		Part Number:	D4037-3
Inspection Dwg: D4037 Rev: E		Page 2 of 2	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
R0.32	+/-0.030	0.320	✓		2-G	
0.200	+/-0.010	0.205	✓		K-05	venm.
0.64	+/-0.030	0.670	✓		" "	" "
0.45	+/-0.030	0.460	✓		" "	" "
0.70	+/-0.030	0.730	✓		K-05	venm.
0.25	+/-0.030	0.250	✓		" "	" "
R0.13	+/-0.030	0.130	✓		2-G	
0.49	+/-0.030	0.500	✓		K-05	venm.
0.06	+/-0.030	0.060	✓		" "	" "

Measured by: <u>DAS</u> <u>1 KJ</u>	Audited by: <u>AF</u>	Preliminary Approval:
Date: <u>9-89</u> <u>17-12-21</u>	Date: <u>17-12-22</u>	Date:

Rev	Date	Change	Revised by	Approved
A	10.06.08	New Issue	KJ	
B	10.10.07	Dimensions updated per Dwg Rev C	KJ	
C	11.06.21	Dwg Rev updated	KJ	
D	17.02.16	Dimensions updated per Dwg Rev E	KJ	